

Work Order ID 63690

November 10, 2010 9:05:31 AM

Page 1

Item ID: D4015-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearbar Weldment

Start Date: 11/10/10 Start Qty: 70.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 70.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4015

B

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

Q 10-11-23 (72)

110

Weld per dwg A/R Hardcoat S.S. Batch: M

0.00

Large Fab

Memo

0.00

Large Fab

Q 10-11-23 (72)

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 10/11/23

counts (72)

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Page 2

Item ID: D4015-041

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Item Name: Wearbar Weldment

Start Date: 11/10/10 Start Qty: 70.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 70.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

8.00/11/23

Count
72

QC

Memo

0.00

Quality Control

135

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

11/12/24

22H 10/11/24

x72

Ø

Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 9:30 AM

Oven Temperature: 320°F

Finish Time: 10:00 AM

136

QC3- Inspect Part Finish

0.00

11/11/24

22H

QC

Memo

0.00

Quality Control

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Page 3

Item ID: D4015-041

Accept

Setup Start

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Item Name: Wearbar Weldment

Start Date: 11/10/10 Start Qty: 70.00

Required Date: 11/15/10 Req'd Qty: 70.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location *114*

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/11/24**10/11/25*
MF
10-11-24

Picklist Print

November 10, 2010 9:05:30 AM

Page 1

Work Order ID: 63690



Parent Item: D4015-041



Parent Item Name: Wearbar Weldment

Start Date: 11/10/10

Required Date: 11/15/10



Start Qty: 70.00

Required Qty: 70.00

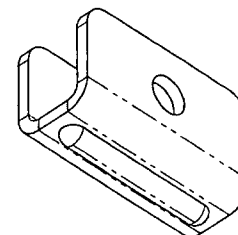
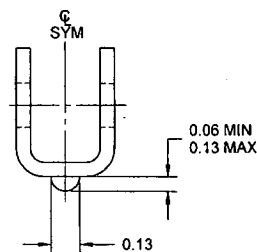
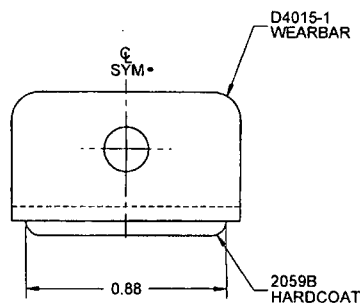
Comments:

IPP RevA: New issue 09.11.03 DD verified by:EC
remove waterjet 09.11.03 DD verified by:EC
dwg 09.11.18 DD verified by:JLM

IPP RevB:
IPP RevC: revB as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4015-1  Wearbar		Manufactured	No			100	Each	0.0000	1	70			
63692 x 72											EL 10/1/23		

ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



D4015-041 WEARBAR WELDMENT

W1063690

RELEASED
2009-11-24

NOTES:

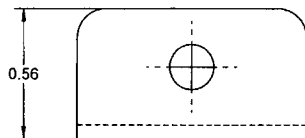
- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

B	CHANGED COLOR TO BLACK SANDEXT	MB	09.11.13
A	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.13		

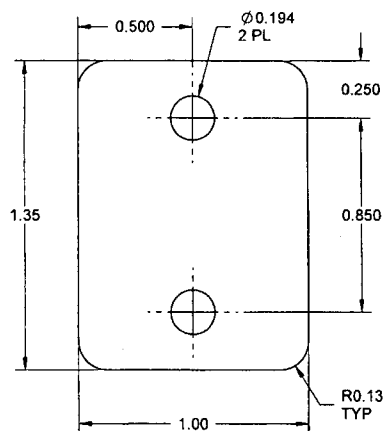
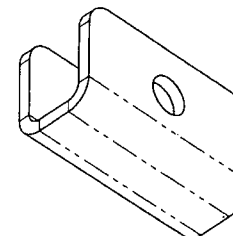
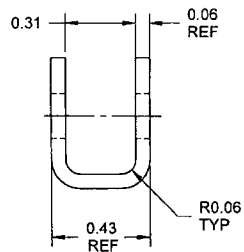
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4015** REV. **B**
SHEET 1 OF 2
TITLE **WEARBAR WELDMENT** SCALE **NTS**

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D4015-1 WEARBAR
MAKE FROM D4015-1



D4015-1F WEARBAR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

63696

RELEASED
2009-11-24

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4015	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARBAR WELDMENT	NTS
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